



Dart Aerospace Ltd.
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D3204-041
Job Sheet 203153



Part No: D3204-041

Job Qty: 4 pcs

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/2/19

Description:

Type: Stock

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	12/2/19		0.00	5.19	Large Fab - 1		<i>CL</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	4 pcs	12/2/19		0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	12/2/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



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Container No: S259509



Part: D3204-041

Job No: 203153

Serial No/Batch: S259509

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/28/20

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				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130 Handfinish - 1-1 Chemical- B4B	4	12/2/19	0.00 0.38	Handfinish - 1 - 1 - B4B	
pcs				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ MAR 02 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 Powdercoat - 3 Grey Sand - B4B	4	12/2/19	0.00 0.30	Powdercoat - 1 - B4B	REB 20.03.02
pcs				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
150 QC 3	4	12/2/19	0.00 0.00	QC 3 - 10	
pcs				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	DAS 30 MAR 02 2020
				QC 3 - 34	9-89
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	

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					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
160 Small Fab - 2 - B4B	4 pcs	12/2/19	0.00 0.27		Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
170 QC 5	4 pcs	12/2/19	0.00 0.00		QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
180 Packaging 3-1 - Stock - B4B	4 pcs	12/2/19	0.00 0.00		QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

MAR 02 2020

DAS
30
9-89 MAR 12 2020DAS
28
9-89

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	4 pcs	12/2/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

MAR 02 2020

Part Op 100 - (Fabricate per Drwg) 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts Descriptions: D3204-1,3,5,13 in jig number DT10295 for tacking parts together.3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and D3204-5; weld parts then after parts have cooled; remove spacing rods...4- Inside measurement should be @ 5.9". Then proceed to installing D3204-11 plate, then D3204-9 pedal.5- Fill #30 hole when parts are cooled to room temperature quickly at around 150 amps... *M134785*

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Chemical Conversion Coat per QSI005 4.1)

140 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE: *320°*

150 - (QC3- Inspect Part Finish)

160 - (Small Fab)

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____) LOCATION : GA

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	<i>5189084</i>
D3204-11	Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	<i>5173550</i>
D3204-13	Gusset	8 pcs (2 ea)	100-Large Fab - Welded Assy-1	<i>5232511</i>
D3204-3	Arm	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	<i>5173655</i>
D3204-5	Arm	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	<i>5252039</i>
D3204-9	Pedal	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	<i>5173681</i>
D3204-7	Bushing	8 pcs (2 ea)	160-Small Fab - 2 - B4B	<i>5194951</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D3204-1	4	24	0
	D3204-11	4	14	0
	D3204-13	8	0	0
	D3204-3	4	12	0
	D3204-5	4	12	0
	D3204-9	4	13	0
	D3204-7	8	36	0
160-Small Fab - 2 - B4B				

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Machining ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Rec/Store/Packaging ☐ Cross tube ☐ Small Fab ☐ Finishing ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY							
				Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
				Other/Details: _____							
Completed By				Lead hand / Supervisor							
QC / QA Coordinator											